

Date: Tuesday, 04/11/2008 2:03:22 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SQUARE TUBE  
 Job Number : 43199 -1  
 Estimate Number : 13420  
 P.O. Number :  
 This Issue : 04/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : LARGE FAB ASSY  
 Previous Run : 42603  
 Written By :  
 Checked & Approved By : MF 08-11-04  
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Part Number : PB6743001207  
 Drawing Number : B6743001 P.5/ P.16  
 Project Number : N/A  
 Drawing Revision : B1  
 Material :  
 Due Date : 11/11/2008 Qty: 10 Um: Ear

split  
6

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W120	6061T6 SQ TUBE 1.00 x 1.00 X .120w
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
3.0	QC5	INSPECT WORK TO CURRENT STEP
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
5.0	QC5	INSPECT WORK TO CURRENT STEP



Comment: Qty.: 1.9469 f(s)/Unit Total : 9.7346 f(s)

6061T6 SQ TUBE 1.00X.120

batch: M109928

SAP 08-11-20



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- make a 0.090" chamfer on both ends of tube

3- deburr

SAP 08-11-20



Comment: INSPECT WORK TO CURRENT STEP

SAP 08/11/20 (410)



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes as per dwg

2- make a 0.090" chamfer (100 degree) on both side of the 4 holes

3- deburr

SAP 08/11/24

(10)



Comment: INSPECT WORK TO CURRENT STEP

SAP 08/11/24





## Process Sheet

ner: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Number: 43199

Part Number: PB6743001207

Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

batch:

~~B40272~~ → 8 ~~B24005~~ → 16  
~~B40272~~ → 8 ~~B24005~~ → 16

Cpl 08.11.25

7.0

PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Square Cap

batch:

~~B42604~~ → 6 B42604 → 6

Cpl 08.11.25

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

Cpl 08.11.25

(x6)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

SAD 08-11-26  
Cpl 08.11.26

9

10.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/11/26

(x6)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/26

(x6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

438

Glub

(6x)

SP

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

mf 08-11-26

















